

Date: Thursday, 3/2/2006 3:07:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET, GAS SPRING STUD
Job Number	: 26026		
Estimate Number	: 10183		
P.O. Number	: N/A	Part Number	: D2154
This Issue	: 3/2/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2154 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: C
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>See COMMENT BELOW</u>	Due Date	: 3/20/2006
Checked & Approved By	: <u>06.03.02</u>	Qty:	20 Um: Each
Comment	: Est: C 03.08.08 Reformat; Remove Tumble KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 705

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D2154

Material release note is required

U 06-03-03

2.0	D2154F	Bracket, Stud
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 BRACKET, GAS SPRING STUD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

06-04-04 (20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAN 06:04:06 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 26026

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SB 06/04/17

(19)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.04.17

15

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/04/19

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 9/4/20 (19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST26

P 9/4/20 (19)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206.04.21 (19)

Job Completion




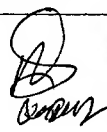
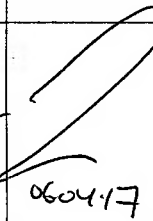


U 06.04.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

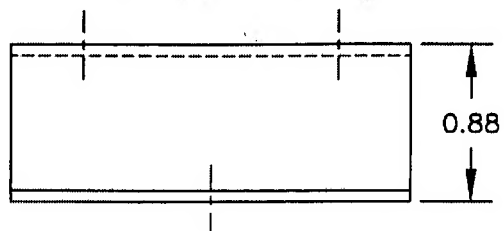
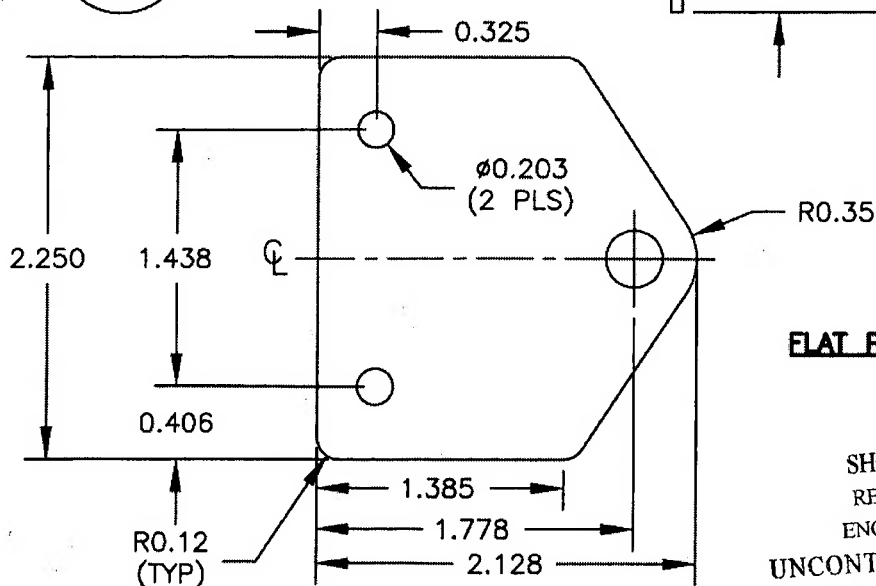
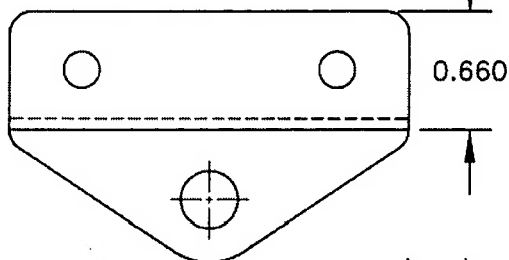
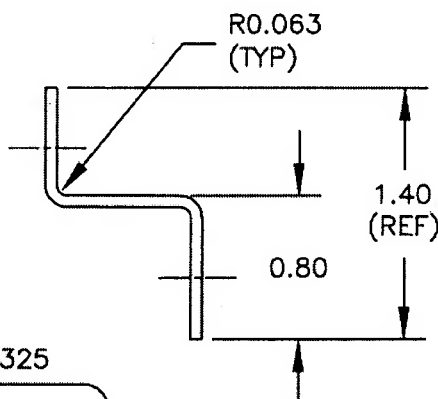
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 06/07/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-17	6	1 part missing ???		Qty 19.				

NOTE: Date & initial all entries

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26026*

D2154 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate 185045 02 Mail To:
ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:
ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

Corrosion: ASTM A262/01E, 180 Band-OK

Your Order: V033868

NAS Order: AE 0249852 03

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01, A480/01, A666/00, ASMESA240/01, SA480/01, SA666/01
QQS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	48.68	85.00	88.00

MILL

MILL TEST CERTIFICATES

705

870

YIEH MAU CORP.

ORIGINAL

INVOICE NO. : F05M920

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : OLHEET METAL SALES LIMITED

I.A.: 高雄縣竹園鄉新港345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL: (07) 6972845 FAX: (07) 6978008
CERTIFICATE NO.: F05M920
DATE OF ISSUE: 10/28/2005

TOTAL P.04

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50mm					Chemical Composition (%)								
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK-PASS)																			
24GA / 48" X 96"	1	1,367	3,014	N8853719	48S71574-12	265	541	58	78	150	6	37	72	25	6	804	1800	3.7	
24GA / 48" X 120"	1	1,149	2,533	N8853719	48S71674-13	266	541	58	78	150	6	37	72	25	6	804	1800	3.7	
24GA / 48" X 120"	1	946	2,086	N8853719	48S71574-14	266	541	58	78	150	6	37	72	25	6	804	1800	3.7	
16GA / 36" X 96"	1	1,809	3,984	YU235551	48S12437-315	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-313	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-314	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 60" X 96"	1	1,360	2,976	YU139585	48S14145A-21	302	654	58	78	144	4.7	49	126	82	6	805	1822	3.1	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-13	306	647	51	80	155	4.8	53	113	81	6	808	1832	3.1	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-14	306	647	51	80	155	4.8	53	113	81	6	808	1832	3.1	
14GA / 48" X 96"	1	1,894	3,078	YU235525	48S11899H-15	316	682	51	83	164	4.8	53	126	29	5	804	1808	3.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-16	316	682	51	83	164	4.8	53	126	29	5	804	1808	3.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-17	316	682	51	83	164	4.8	53	126	29	5	804	1808	3.3	
11GA / 48" X 120"	1	1,862	3,642	YU139676	48S14905A-112	306	656	51	84	166	6	48	111	29	11	805	1825	2.2	
11GA / 48" X 120"	1	1,862	3,642	YU139676	48S14905A-113	306	656	51	84	166	6	48	111	29	11	805	1825	2.2	
TOTAL:		14	17,527	38,638															
Remarks: NO MERCURY CONTAMINATION Bend test good for all Heat NO.																			
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS																			

P50908PC001V

YIEH MAU CORP.

Manager of Quality Assurance Section